

5/24

DART AEROSPACE LTD	Work Order:	23245
Description: Inner Fwd Saddle	Part Number:	D5953
Drawing: D5953 Rev. A	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg not required</i>	HA	05.05.11	8
2	STORES	Issue material from stock: D6101-007 (7075-T7351) Cut Size 2.50" x 7.50" X 8.25" (Grain along 7.50") B23250 Batch: 323245	ML	05/01/30	8
3	HAAS	Setup W/O No. 323245 23245 Setup Inspection last completed 176 by	NA	05/07/03	8
4	HAAS	Machine as per folio D5953 Ensure Batch Number is entered	EC	05.07.03	8
5	HAAS	Deburr and Tumble	EC	05.07.03	8
6	QC	Inspect Level 1 Fill Out Inspection Sheet	EC	05.07.03	8
7	QC	Inspect Level 8 Audit Inspection Sheet	SA	05.07.04	8
8	METAL	Acid etch and alodine as per QSI 005 4.1	FF	05.07.06	8
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	FC	05.07.08	8
10	QC	Inspect Level 3	ML	05.07.08	8
11	STORES	Pack in foam, identify and stock	DL	05/07/09	8
12	EXPEDITING	Close Work Order 176.17 Inspect level 21 Cost / Part : 176.17	AC	05/07/11	8

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06

03.05.16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	23245
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D5953 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.749	1.750	1.750		
C	5.245	5.255		5.250	5.248	5.250	5.250		
D	6.995	7.005		6.998	6.998	7.000	6.999		
E	5.745	5.755		5.747	5.746	5.749	5.745		
F	4.745	4.755		4.748	4.746	4.750	4.750		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.526	1.525	1.525	1.525		
I	3.048	3.058		3.055	3.054	3.055	3.055		
J	4.575	4.585		4.580	4.578	4.579	4.579		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		0.244	0.248	0.246	0.245		
M	0.490	0.510		0.503	0.505	0.504	0.503		
N	0.240	0.260		0.248	0.249	0.244	0.248		
O	7.990	8.010		7.998	8.001	8.001	8.000		
P	0.240	0.260		0.259	0.258	0.253	0.254		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.762	0.763	0.763	0.763		
S	0.490	0.510		0.493	0.506	0.504	0.497		
T	1.375	1.395		1.384	1.386	1.386	1.386		
U	2.000	2.020	DT8696 A/B	✓	✓	✓	✓		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	E
Date:	05-07-07

Audited by:	SD
Date:	05-07-07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF RF	#

RELEASED
03.06.18

DART AEROSPACE LTD		Work Order: 23245
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5953 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.249	5.249	5.249		
D	6.995	7.005		7.000	7.000	7.000	6.999		
E	5.745	5.755		5.749	5.749	5.750	5.750		
F	4.745	4.755		4.749	4.749	4.749	4.750		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.528	1.527	1.527	1.527		
I	3.048	3.058		3.054	3.054	3.052	3.052		
J	4.575	4.585		4.580	4.580	4.581	4.580		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		0.246	0.244	0.246	0.248		
M	0.490	0.510		0.504	0.503	0.501	0.503		
N	0.240	0.260		0.247	0.246	0.244	0.248		
O	7.990	8.010		8.000	7.999	8.002	8.001		
P	0.240	0.260		0.244	0.246	0.245	0.245		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.762	0.762	0.763	0.763		
S	0.490	0.510		0.504	0.497	0.496	0.503		
T	1.375	1.395		1.385	1.383	1.384	1.384		
U	2.000	2.020	DT8696 A/B	✓	✓	✓	✓		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ES
Date:	05-07-03

Audited by:	SD
Date:	05-07-04

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF RF	#

RELEASED
03.06.18 RF

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 09, 2005
02:16 pm

Work Order No	: 0023245	Department Code:	
Project Name	: D5953	Burden Flags	: NNNNNNNN
Project For	: WK524	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D5953	Invoice Number	:
Description	: Saddle	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 6	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 05-09-05		
Est Finish Date	: 06-10-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00